

Date: Monday, 11/19/2007 4:04:09 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STA 84 BRACKET  
 Job Number : 35851  
 Estimate Number : 11034  
 P.O. Number : N/A Part Number : D28031  
 This Issue : 11/19/2007 S.O. No. : N/A Drawing Number : D2803 REV B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : B  
 Previous Run : 32800 Material : N/A  
 Due Date : 12/5/2007 Qty: 10 Um: Each  
 Written By : John 1120  
 Checked & Approved By : John 1120  
 Comment : Est. A 00.11.06 New Issue EC  
 Est Rev.B Blanks Now Cut on Waterjet 06-06-14 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X10000 6061-T6 Bar .50" x 10.0"



22.1375



Comment: Qty.: 2.0125 f(s)/Unit Total : 20.1254 f(s)  
 6061-T6 Bar .50" x 10.0"

Material: 6061-T6 bar 10.00" x 0.50"

Batch: 105411 B 07-11-26

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per template DT8533

Dwg Rev: B

B 07-11-26

Prog Rev: B

2-Deburr if necessary

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine as per folio FA102

JML 07/11/29

(10)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JML 07/11/29

(10)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F. 07/12/01 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 07/12/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/19/2007 4:04:09 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 84 BRACKET

Job Number: 35851

Part Number: D28031

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Tumble & Deburr

2.5 07/12/01 (10)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07/12/03 (10)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

BR 07-12-03 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: ST 152

AS 07/12/04 (10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/12/04


Job Completion



07/12/03

07/12/04

8.1 QC 43 - Fx 07/12/03 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
7/12/03	8.1	Perment change ADD A QC # 3 inspection					 7/12/03

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>35851</b>
<b>Description: Bracket</b>		<b>Part Number:</b>	<b>D2803-1</b>
<b>Inspection Dwg: D2803 Rev: B</b>		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	Ø0.7590	—			
Ø0.191	+0.005/-0.000	Ø0.192	—			
Ø0.507	+0.000/-0.001	Ø0.5065	—			
13.558	+/-0.010	13.558	—			
Ø0.507	+0.000/-0.001	Ø0.507	—			
12.411	+/-0.010	12.411	—			
2.654	+0.000/-0.001	2.654	—			
0.437	+0.000/-0.001	0.437	—			
1.420	+/-0.001	1.419	—			
6.933	+/-0.010	6.933	—			
0.250	+/-0.010	0.252	—			
0.875	+0.000/-0.001	0.8742	—			
0.250	+0.000/-0.005	0.246	—			
0.125	+/-0.010	0.123	—			
0.125	+/-0.010	0.127	—			
0.125	+/-0.010	0.123	—			
0.125	+/-0.010	0.120	—			
0.500	+/-0.010	0.501	—			
0.562	+/-0.010	0.563	—			
0.188	+/-0.010	0.191	—			

<b>Measured by:</b>	<i>gmk</i>	<b>Audited by:</b>	<i>gfk</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	07/11/29	<b>Date:</b>	07/12/01	<b>Date:</b>	N/A

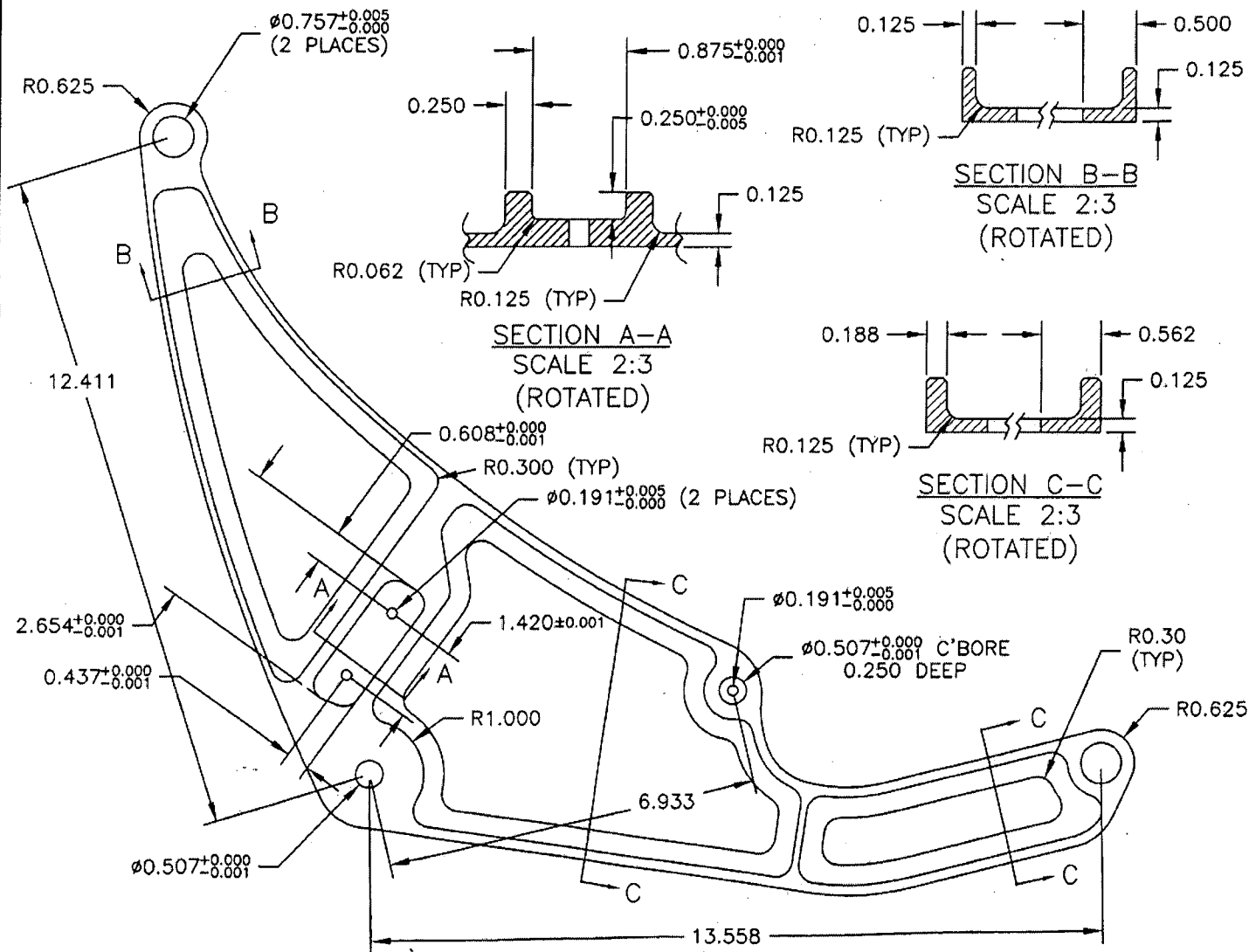
Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	07.07.18	12.625 dimension removed	KJ/JLM	<i>gfk</i>

**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO. D2803
				REV. B SHEET 1 OF 2
DATE	04.11.22	TITLE	STA 84 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE		
B	04.11.22	ADD CUTOUTS & -043/-044		

**RELEASED**

05-03 11

**D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

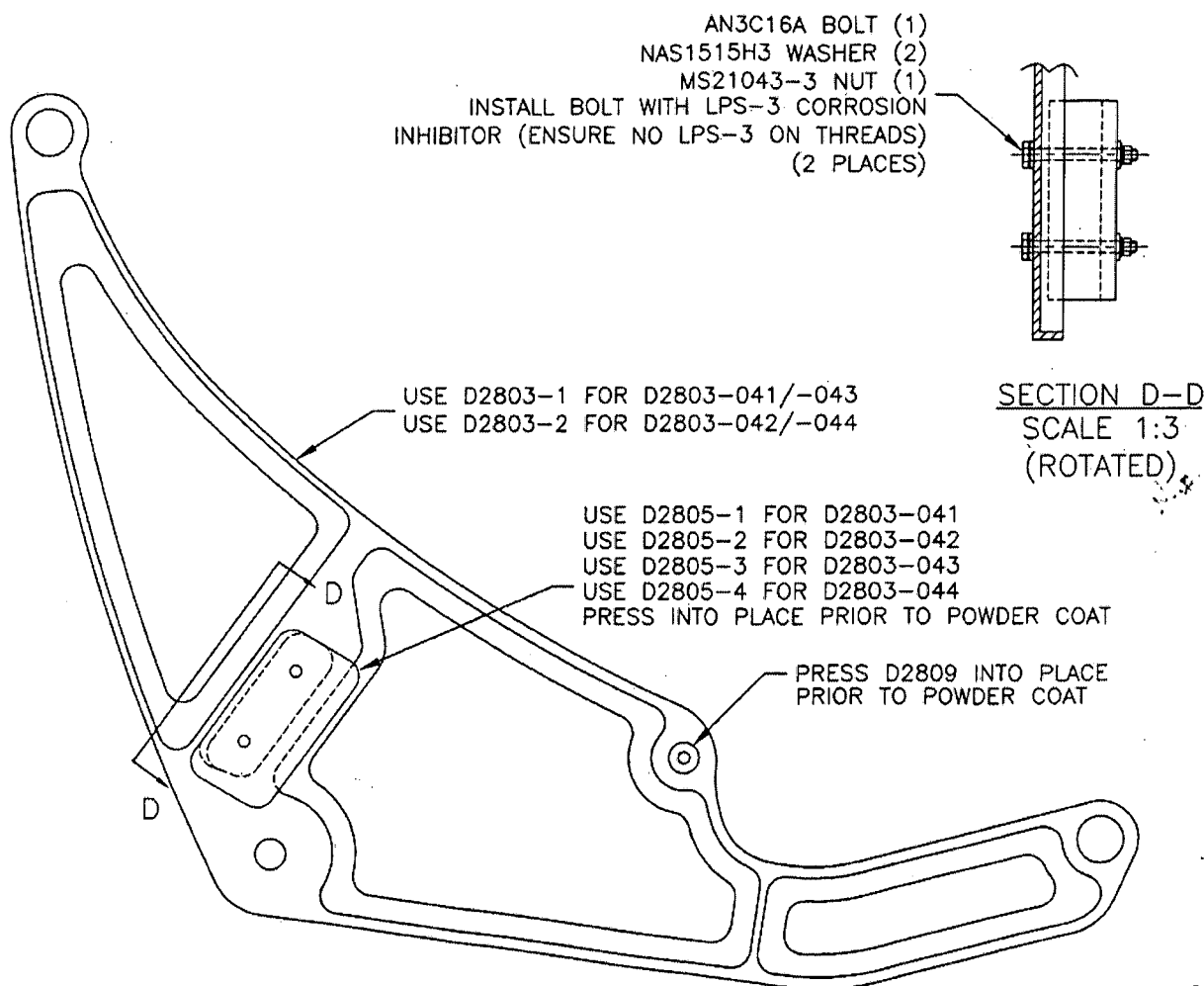
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22	TITLE STA 84 BRACKET		SCALE 1:3



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**D2803-041/-043 BRACKET ASS'Y (SHOWN).**  
**D2803-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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